

Work Order ID 83177

April-13-12 12:57:18 PM

83177

Page 1

Item ID: D3507-1-BENT

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube Assembly EC135

Start Date: 13/04/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 19/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/13

Tooling:

Date:

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3507	Rev C

120

0.00

120

BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1- Bend tube as per program D3507 on CNC Bender FOLIO 6 and Dwg D3507,
use DT9632 bending aide
2- Cut FWD END of tube as per dwg D3507

DC 12/05/17

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

DP 12-5-17

300

Identify as per dwg & Stock Location: 46

0.00

300

Packaging

Packaging

Memo

0.00

DP 12-5-17

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item ID: D3507-1-BENT

Revision ID:

Item Name: Skidtube Assembly EC135

Start Date: 13/04/2012 Start Qty: 2.00

Required Date: 19/04/2012 Req'd Qty: 2.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2******2***

Cust Item ID:

2

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

310

QC21- Final Inspection - Work Order Release

0.00

310

QC

Memo

0.00

Quality Control

12/5/22
ME
12-05-22

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Picklist Print

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Work Order ID: 83177

Parent Item: D3507-1-BENT

Parent Item Name: Skidtube Assembly EC135

83177

D3507-1-BENT

Start Date: 13/04/2012

Required Date: 19/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 10.09.17 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2962-150 Manufactured

No

100

Each

32.0000

1

2

D2962-150

3.540 Outer Tube, Extrud

**

DC 12/05/17

Location

Loc Qty

Loc Code

HALL

32

59934

32

(2)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

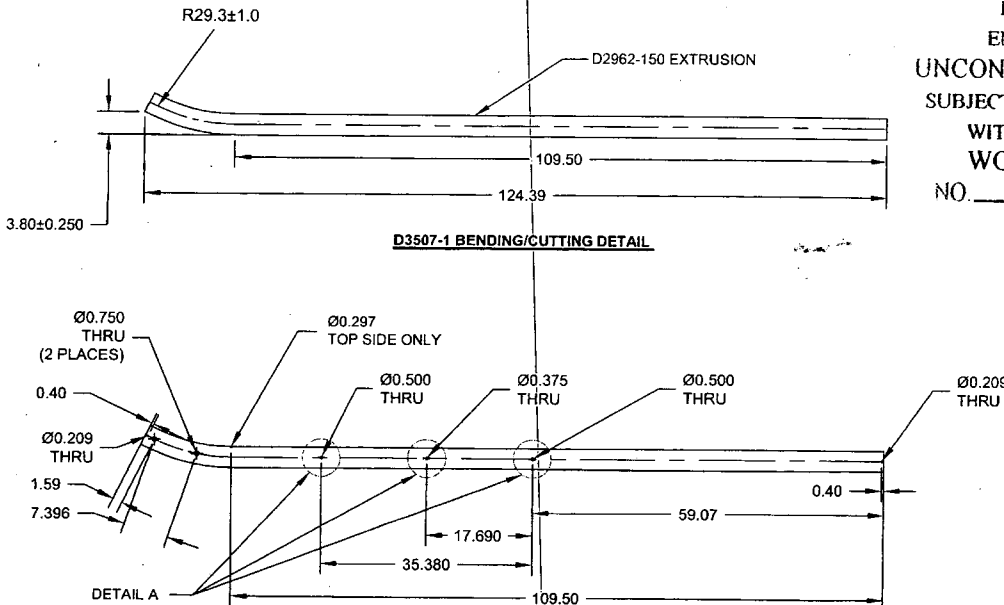
NO. 83177 MLJ
12/04/13

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

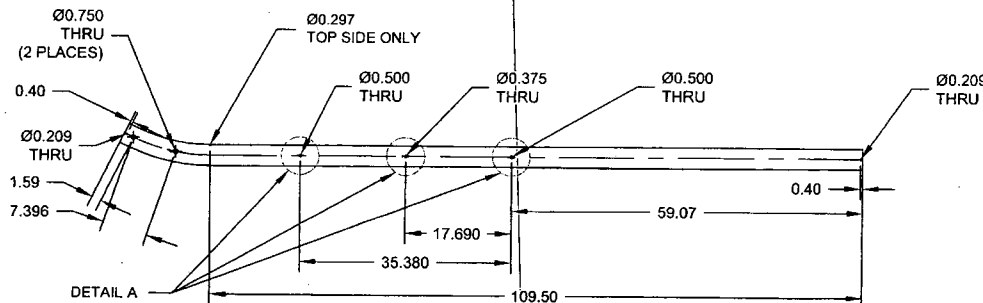
GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING
D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER
DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND
WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER
DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38
PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38
PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED
LOCATIONS

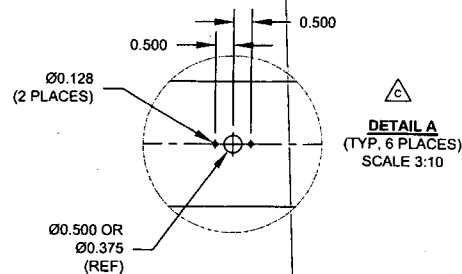
C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032:10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	JTC		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.09.19		
DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3507 TITLE EC 135 SKIDTUBE REV. C SHEET 1 OF 2 SCALE NTS COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL



DETAIL A
(TYP. 6 PLACES)
SCALE 3:10

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